

Date: Tuesday, 9/26/2006 2:40:27 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY RH \*UNDER REVIEW\*\*  
 Job Number : 28723  
 Estimate Number : 12439  
 P.O. Number : *N/A*  
 This Issue : 9/26/2006 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : LARGE FAB ASSY  
 Previous Run : 28394  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: B 04.04.11 Combined with D2943-041 EC

Part Number : D058677012  
 Drawing Number : D2943 UNDER REVIEW *OK*  
 Project Number : N/A *06-09-26*  
 Drawing Revision : *UNDER B*  
 Material : *N/A*  
 Due Date : 10/10/2006 Qty: 3 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



(3)

Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG 001 *KJ* 06-10-03

2.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Extrusion D2622-120C  
 Batch: *327077*

*PE. 06-09-28*

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 D2734 206 Step Endplate  
 Batch: *327281*

*PE. 06-09-28*

4.0 D2725 206 Step Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 D2725 206 Step Lug  
 Batch: *320783*

*PE. 06-09-28*

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8483

*PE. 06-09-28*  
*PE. 06-09-28*  
*PE. 06-09-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:40:27 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH \*UNDER REVIEW\*\*

Job Number: 28723

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: M15689 M19612

FE. 06.09.29 3

4-Grind end cap welds flush as per dwg D2943

FE. 06.09.29 3

6.0

QC5/9

WELD INSPECTION



0610.03 (3)



Comment: WELD INSPECTION

11/06/10/04 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.10.09 (3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE. 06.10.17 3

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: M18838

FE. 06.10.17 3

2-Grind end cap welds flush as per dwg D2943

FE. 06.10.17 3

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/10/18 (3)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 19 (3)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 10 20 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:40:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH \*UNDER REVIEW\*\*

Job Number: 28723

Part Number: D058677012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: 102098

FC 06 10 23 (3)

14.0	QC3/5	INSPECT WORK/WING WALK
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Comment: INSPECT WORK/WING WALK

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0	D27311	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B20613 -

17.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B20614

18.0	D27315	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B22591

19.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mounting Lug

Batch: B22592 Incp -

B22592 Smp -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:40:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY RH \*UNDER REVIEW\*\*

Job Number: 28723

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M100743

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Batch: M101390-

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

Batch: M19099--

06/10/24 (3)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/10/24 (3)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location:

PPP Rev: B

06/10/25 (3)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/25

Job Completion



C 06/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

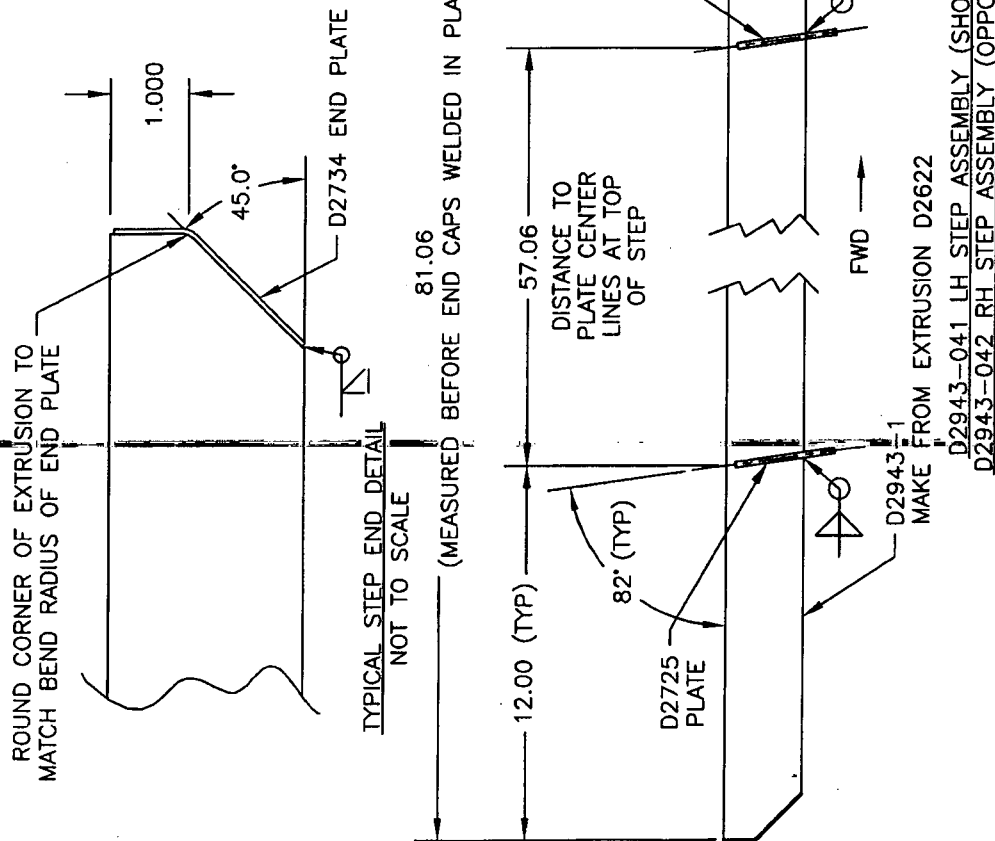
**NOTE:** Date & initial all entries



**DART**

DESIGN	RF	DRAWN BY	RH	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	REV. B
05.11.14		05.11.19		D2943	SHEET 1 OF 1
DATE		TITLE		OH-58 STEP ASSEMBLY	
A		NEW ISSUE		SCALE	
B		UPDATE FINISHING NOTE		NTS	

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**UNDER REVIEW**

06.03.29 RH

RE-DESIGN  
SIMILAR TO D206-528**RELEASED**  
05.11.28

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 28723

**D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
X	-041	D2943-041	LH STEP ASSEMBLY
X	-042	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

\*cut per drawing

**D2943-041/-042 OH-58 STEP ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 26/10/2006 11:35:40 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : D058-677-011/-012
<b>Job Number</b> : 29185	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : Z_CUSTOM
<b>This Issue</b> : 26/10/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : ADD MISSING HARDWARE
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : <i>N/A</i>
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : OVERHEAD	<b>Drawing Revision</b> : <i>N/A</i>
<b>Previous Run</b> : 00015	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : _____	<b>Due Date</b> : 02/11/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : _____	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
REMOVE AND QUARANTINE:  
D058-677-011 B *B28722*  
  
D058-677-012 B *28723*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
ADD TO EACH KIT  
12 X AN960JD416 WASHER B *M102339*

3.0	AN960JD416	Washer
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**Comment:** Qty.: 12.0000 Each(s)/Unit Total : 96.0000 Each(s)  
Washer *M102339*

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
REPACKAGE PER PPP

Date: Thursday, 26/10/2006 11:35:40 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D058-677-011/-012

Job Number: 29185

Part Number: Z\_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

NOTE:

ADD A COPY OF THIS W/O WITH EACH OF  
THE ABOVE BATCHES PULLED FROM STOCK

B 28722

B 28723

(2)

SP 06/10/27

Job Completion



U 10.27

## 32.4 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D058-677-011	HELI-ACCESS-STEP™, LH
	X			D058-677-012	HELI-ACCESS-STEP™, RH
		X		D058-677-013	HELI-ACCESS-STEP™, LH
			X	D058-677-014	HELI-ACCESS-STEP™, RH
1		1		D2943-041	STEP ASSEMBLY LH
	1		1	D2943-042	STEP ASSEMBLY RH.
		2	2	D2230-1	MOUNTING LUG
		2	2	D2230-3	MOUNTING LUG
2	2			D2731-1	MOUNTING LUG
2	2			D2731-3	MOUNTING LUG
2	2	2	2	D2731-5	MOUNTING LUG
2	2	2	2	D2731-7	MOUNTING LUG
4	4	4	4	AN4-11A	BOLT
8	8			AN4-12A	BOLT
		8	8	AN4-14A	BOLT
12	12	12	12	AN960JD416	WASHER
12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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